

5/46

DART AEROSPACE LTD	Work Order:	24683
Description: Handle Weldment	Part Number:	D3135-041
RF 04.11.29		
Drawing: D3135 Rev. <i>BC</i>	Qty:	3
D3135-041 replaces Premier P/N: B30-23000-39 D3135-1/-3 replaces Premier P/N: B30-23000-215/-217		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	<i>HA</i>	05.10.26	3
2	PG	Issue P/O: <i>2008867</i> Email or ship DXF file to vendor Laser cut D3135-3 per Dwg D3135 Material: AISI 304/316 SS sheet 0.063 thick (Ref Spec: M304S16GA) Annealed Material release note required	<i>HA</i>	05/10/27	3
3	RG	Receive and inspect for transit damage. Ensure the material release note is attached	<i>u</i>	05/11/22	3
4	QC6	Inspect dimensions per template D3135-3T1 and Dwg D3135	<i>2</i>	05.12.13	3
5	GA	Deburr if necessary	<i>SAD</i>	05/12/20	3
6	MS	Cut D3135-1 Handle as per template D3135-1T1 and Dwg D3135 Material: AISI 304/316 SS tubing Ø0.375" x 0.065 wall (M304TR0.375W.065) Annealed Batch: <i>M10457</i>	<i>FF</i>	06.01.31	3
7	MS	Deburr ends	<i>FF</i>	06.01.31	3
8	MS	Bend D3135-1 as per template D3135-1T2 and Dwg D3135	<i>FF</i>	06.02.01	3
9	QC5	Inspect work to Step 8	<i>2</i>	06.02.01	3
10	MS	Weld handle onto plate as per Dwg D3135 and QSI 004	<i>CPL</i>	06.02.13	3
11	GA	Scribe Dart P/N as per Dwg D3135	<i>SD</i>	06.02.20	3
12	QC9/5	Inspect work to Steps 10 & 11	<i>HA</i>	06.02.13	3
13	FP	Powder Coat Grey Sandtex (4.3.5.6) per QSI 005 4.3	<i>FC</i>	06.02.20	3
14	QC3	Inspect Powder Coat	<i>M</i>	01.02.22	3
15	ST	Identify and Stock in Spacedoor Cell with P/N + B/N using fine point permanent ink marker	<i>u</i>	01/2/22	3
16	AC	Cost/part	<i>u</i>	06.02.23	3
17	DC	Close W/O Inspect level 21	<i>SD</i>	06/02/23	3

RF
04.11.29

Rev	Date	Change	Revised By	Approved
A	03.03.06	New Issue	KJ/RF <i>RF</i>	<i>HA</i>

RELEASED
03.03.07 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/02/23

QA: N/C Closed: _____ Date: _____

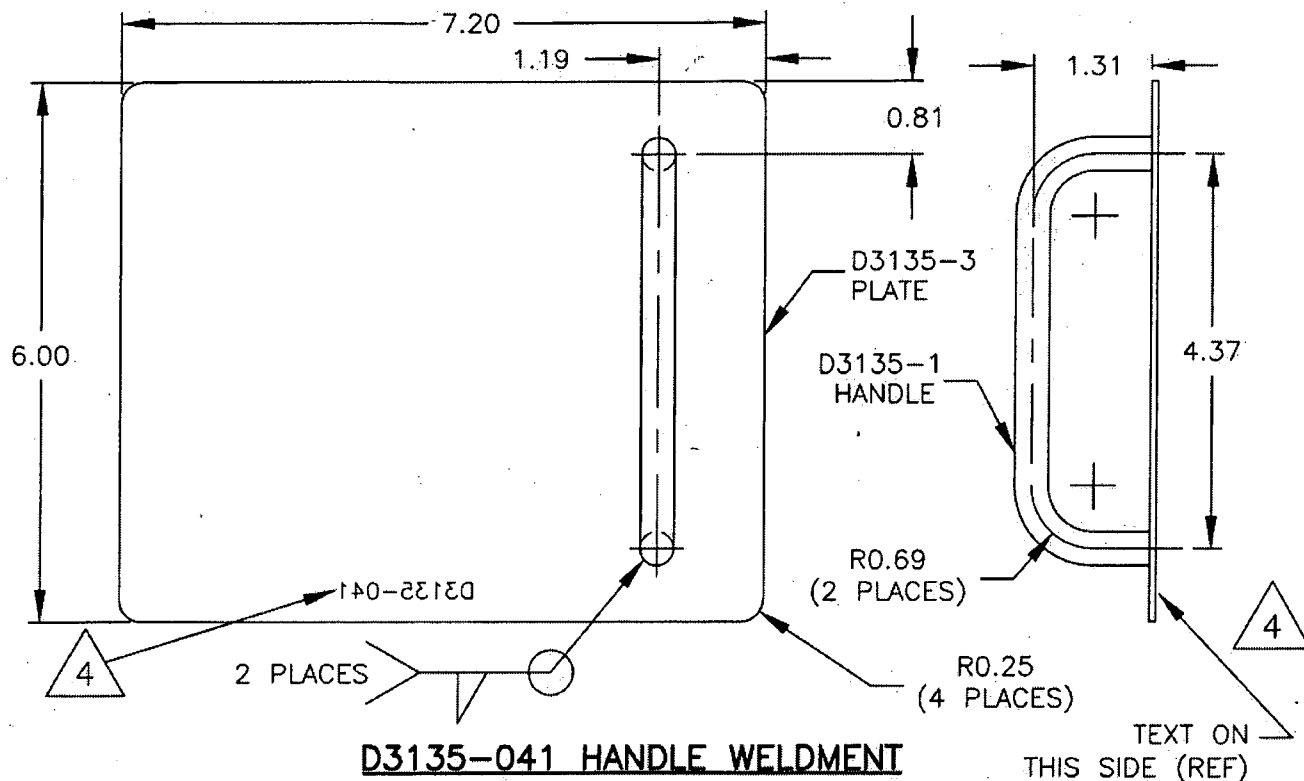
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3135	REV. C SHEET 1 OF 1
DATE 04.10.06		TITLE HANDLE WELDMENT	SCALE 1:2
A	02.04.17	NEW ISSUE	
B	03.03.04	6.400 WAS 6.330; ADD "ANNEALED"	
C	04.10.06	REMOVED $\phi 0.221$ HOLES	

RELEASED
04.11.03



D3135-041 HANDLE WELDMENT

- 1) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-39
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) IDENTIFY TOP ASSEMBLY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

D3135-1 HANDLE

- 5) MATERIAL: AISI 304/316 SS TUBING $\phi 0.375 \times 0.065$ WALL
(REF DART SPEC. M304TR0.375W.065) ANNEALED

D3135-3 PLATE

- 6) MATERIAL: AISI 304/316 SS SHEET 0.063 THICK (REF DART SPEC. M304S16GA) ANNEALED

GENERAL NOTES

- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) BREAK ALL SHARP EDGES 0.005 TO 0.015

NOT FOR
RETURN TO
ENGINEER

NOT FOR
SUBJECT TO
WITH IC

24683

Copyright © 2002 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Job Costing Report

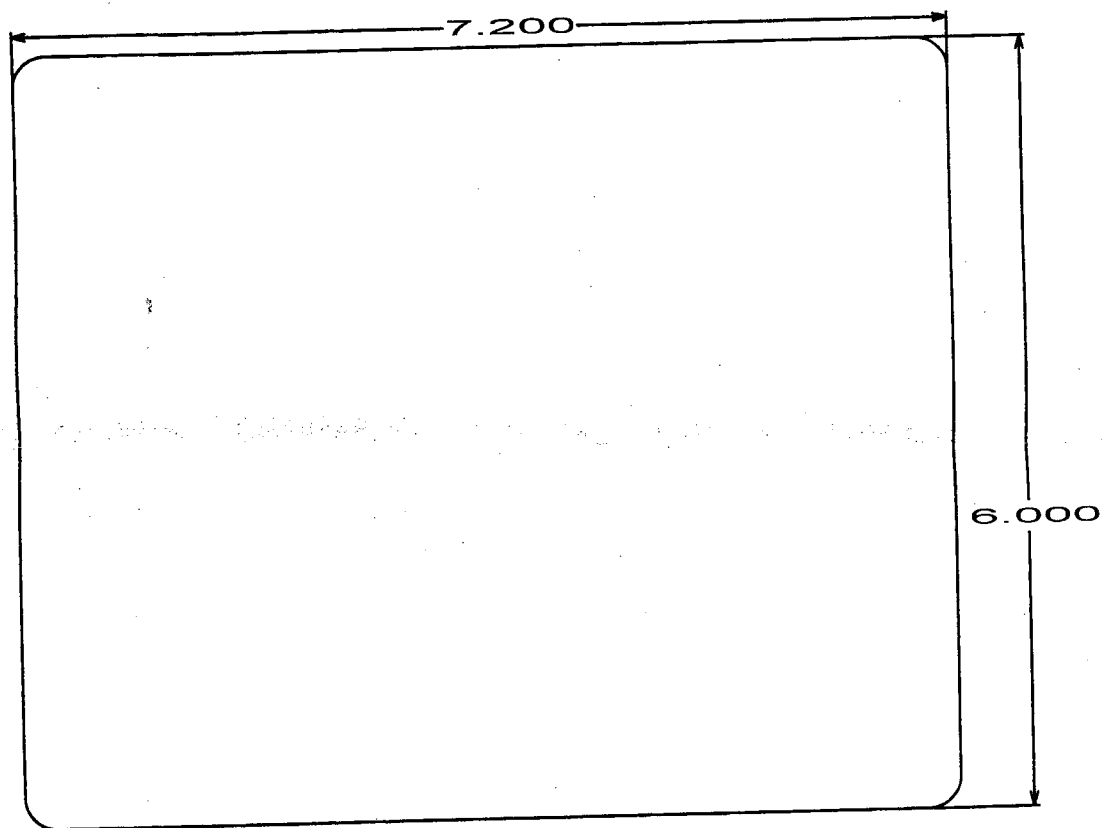
Dart Aerospace Ltd.
Hawkesbury

Oct 25, 2005
04:04 pm

Work Order No	: 0024683	Department Code:	
Project Name	: D3135-041	Burden Flags	: NNNNNNNN
Project For	: WK546	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3135-041	Invoice Number	:
Description	: Handle Weldment	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 3	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 10-25-05		
Est Finish Date	: 11-15-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00



D3135-3c
16ga ss

3pcs

ALGOMA STEEL INC.

105 West St., Sault Ste. Marie, Ontario, Canada, P6A 7B4

CUSTOMER PURCHASE ORDER NUMBER P50210ME002	ENTRY DATE 2005/02/11	SHIP DATE 2005/03/17	TALLY NUMBER 963428	SHIPPER'S NUMBER 09-	CARRIER NOKL	-381265	MILL ORDER 64103
---	--------------------------	-------------------------	------------------------	-------------------------	-----------------	---------	---------------------

CHARGE TO CUSTOMER NAME & ADDRESS

WILKINSON A DIVISION OF PREMETALCO INC
888 SOUTH EAST MARINE DRIVE
VANCOUVER BRITISH COLUMBIA
V5X 2V3

SHIP TO CUSTOMER NAME & ADDRESS

WILKINSON A DIVISION OF PREMETALCO INC
STATION 9777, FRASER STREET
VANCOUVER, BRITISH COLUMBIA

MILL TEST REPORTS

ALGOMA STEEL INC. HEREBY CERTIFIES THAT THE MATERIAL HEREIN DESCRIBED WAS MADE AND TESTED IN ACCORDANCE WITH THE RULES OF THE SPECIFICATION SHOWN HEREIN AS CONTAINED IN THE COMPANY RECORDS AND WITHIN THE SCOPE OF ACCREDITATION OF ISO/IEC GUIDE 25-1990 AS CONTAINED IN THE COMPANY RECORDS.

B. Thomson
MANAGING METALLURGIST

CUSTOMER SPECIFICATION

HOT ROLLED STEEL SHEET - CARBON - ASTM A1011 TYPE B (03) - CS - MATTE - P & OIL (W/FINISH) - CUT EDGE ACCEPTABLE - SEMI-CRITICAL SURFACE - (AIM FOR LIGHT SIDE OF GAUGE & NO COIL BREAKS) - (FLATNESS CRITICAL)

SUPPLEMENTARY INSTRUCTIONS

FAX SM ATTN M ELIAS 604 301 3244

INSP T/R

CHEMICAL ANALYSIS REPORT REQUIRED

CUST
USE

ELECTRICAL PANELS

2005/03/17 18:07

THIS MILL TEST REPORT MAY NOT BE REPRODUCED EXCEPT IN FULL WITHOUT WRITTEN APPROVAL OF ALGOMA STEEL INC. IF YOU RECEIVE THIS DOCUMENT AND ARE NOT THE INTENDED RECEIVER, PLEASE CALL (705)945-2624 COLLECT FOR INSTRUCTIONS ON METHOD OF DISPOSAL OF DOCUMENT.

MEETS EN 10204 3.1.B AND DIN 50049 3.1.B

***** PRODUCT SHIPPED *****

CUSTOMER ITEM 001 OUR ITEM 001 DIMENSIONS .104 X 48 X COIL

COIL NUMBER	HEAT	NO. PIECES	WEIGHT	COIL NUMBER	HEAT	NO. PIECES	WEIGHT
9591434	1257D-53	1	29840	9591435	1257D-03	1	29440
9591436	1257D-54	1	29800	9591437	1257D-04	1	29040
9591438	1257D-55	1	29830				

***** CHEMICAL PROPERTIES *****

HEAT	C	MN	P	S	SI	CR	NI	CU	MO	AL	CB	V	B
1257D	.05	.36	.011	.007	.02	.02	.13	.04	.01	.027	.000	.001	CA
	.001		.0037										

PAGE 3 OF 3

WARNING

THE TEST RESULTS AND VALUES REPORTED HEREIN INDICATE ONLY THAT (1) THE PARTICULAR STEEL FOR WHICH THIS CERTIFICATE IS ISSUED MEETS THE MINIMUM SPECIFIED YIELD STRENGTH AND (2) THE CHEMICAL ANALYSIS AND PHYSICAL PROPERTIES OF SUCH STEEL ARE IN CONFORMANCE WITH THE REQUIREMENTS OF THE SPECIFICATION INDICATED. THE RESULTS OR VALUES REPORTED HEREIN CAN NOT BE USED TO QUALIFY THE STEEL FOR ANY SPECIFICATION OTHER THAN THE ONE INDICATED AND CAN NOT BE RELIED UPON FOR ANY PURPOSE (INCLUDING DESIGN OR CALCULATIONS) AS REPRESENTING THE ACTUAL STRENGTH OF SUCH STEEL.

SS0830EM007-1 T M INDUSTRIAL (P50210ME002.1257D-04)

9023922

INSPECTION CERTIFICATE

MATERIAL TEST/INSPECTION CERTIFICATES

 燁茂實業股份有限公司
YIEH MAU CORP.

INVOICE NO. : F03MB57
COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET AISI 304, NO.4 (SIC)
FINISH, WITH 100 MIC. FILM ON MAIN SIDE, WITH BACK-PASS,
SLITTED EDGE, AISI 304, 2B FINISH, WITH PAPER INTERLEAVED,
SLITTED EDGE,
AISI 304
SPECIFICATION :
CUSTOMER : INTEGRIS METALS LTD

工廠:高雄縣路竹鄉順安路345號
345, SHUN AN RD. LU CHU HSIANG
KAOHSIUNG TAIWAN R.O.C.
TEL:(07)6972885 FAX:(07)6973006
CERTIFICATE NO:9212243
DATE OF ISSUE:12/31/2003

(ITEM NO) SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test GL=50 m/m					Chemical Composition (%)							
		KGS	LBS			Y.S. (N/mm ²)	T.S. (N/mm ²)	EL. (%)	HRB	H V	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100
AISI 304 2B (7425-4228)																		
24GA/48"X120" (7425-8401)	1	1,442	3,179	YU129992	2AS68986C-1	281	687	56	81	157	4.6	50	110	26	4	804	1819	3.1
20GA/48"X120" (7426-2619)	1	1,446	3,188	YU226021	29S65042BA-21	293	636	58	81	157	4.4	55	115	31	4	808	1808	3.6
18GA/48"X120" (7426-5059)	1	1,428	3,148	YU226201	2AS68982B-21	303	672	56	83	165	4.2	52	115	23	2	814	1824	3.8
16GA/48"X96"	1	1,414	3,117	YU225208	2AS68037-21	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X96"	1	1,412	3,113	YU225206	2AS68037-22	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X96" (7426-5166)	1	1,413	3,115	YU225206	2AS68037-23	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X120"	1	1,385	3,053	YU225390	2AS67026B-1	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/48"X120"	1	1,385	3,053	YU225390	2AS67026B-2	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/48"X120" (7426-5455)	1	1,215	2,679	YU225390	2AS67026B-3	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/60"X96" (7426-5497)	1	1,438	3,170	YU226508	2BS69861A-23	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
16GA/60"X120" (7426-5612)	1	1,411	3,111	YU226508	2BS69861A-22	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
16GA/60"X144" (7426-7949)	1	1,434	3,161	YU226508	2BS69861A-21	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
14GA/48"X96"	1	1,432	3,157	YU130016	2AS68134B-2	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/48"X96" (7426-8053)	1	1,432	3,157	YU130016	2AS68134B-3	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/48"X120"	1	1,435	3,164	YU225138	2AS68038B-1	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X120"	1	1,437	3,168	YU225138	2AS68038B-2	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X120" (7426-8160)	1	1,437	3,168	YU225138	2AS68038B-3	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X144" (7426-8244)	1	1,425	3,142	YU130016	2AS68134B-1	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/60"X96"	1	1,413	3,115	YU130125	2AS69265A-6	299	656	54	83	162	5	47	111	27	2	810	1808	3.6
19		26,834	59,158															

Remarks: NO MERCURY CONTAMINATION
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE CONTRACT.

Bend test: good for all Heat NO.

PRODUCT IN ACCORDANCE WITH ASTM A240, A480,
A262E, ASME SA240, Q3766D.

YIEH MAU CORP.

16ga 304 2B SS

Lin Hsin

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 278331 01 Mail To:
WILKINSON STEEL AND METALS
ATTN: MILL CERTIFICATE SCANNER
888 SOUTHEAST MARINE DRIVE
VANCOUVER, BC V5X2V3
CANADA

Ship To:
WILKINSON STEEL AND METALS
888 SOUTHEAST MARINE DRIVE
VANCOUVER, BC V5X2V3
CANADA

Date: 8/13/2005 Page: 1

Steel: 304

Finish: 2B

Your Order: P50630PC001V

NAS Order: AE 0322595 03

Corrosion: ASTM A262/02aE; 180Bend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a, 480/04a, 666/03, ASME SA240/04, SA480/04, SA666/04
QQS766D-A X MG PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

REMARKS:

Material free from mercury contamination. No weld repairs.
EN 10204 3.1.B QQS763F Cond A

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces
B36382	* 0574K7 BB	.0360	48.0000	2,820 SHEET	96.000	5	62

CHEMICAL ANALYSIS

Heat	C	CR	CU	MN	MO	N	NI	P	S	SI
74K7	.052	18.110	.360	1.642	.304	.064	8.131	.027	.003	.313

MECHANICAL PROPERTIES

Product ID #	Coil #	l d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail Hard
B36382	0574K7	F T	96.33	50.72	45.54	83.50	88.00

QC ENGINEER

ERIC HESS

8/13/2005